

Work Order ID 56324

February 17, 2010 2:39:03 PM



Page 1

Item ID:	D3953-19	Accept:		Setup	Start	
Revision ID:					Stop	
Item Name:	Gas Spring Bracket					
Start Date:	2/17/10	Start Qty:	4.00	Cust Item ID:		
Required Date:	2/24/10	Req'd Qty:	4.00	Customer:		
Reference:						

Approvals:	Process Plan:	<u>M</u>	Date:	<u>10-2-17</u>	Tooling:	Date:	Run	Start	
	QC:		Date:		SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3953	C-PRELIM <u>B</u>								
100		0.00							
	Waterjet								
FLOW CNC Waterjet	Memo	0.00							
364.125	1-Cut as per Dwg D3953								
	Dwg Rev: <u>PRF</u>								
	Prog Rev: <u>Jim</u>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00							
Quality Control									

B 10-2-22

10

B 10-2-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 56324

February 17, 2010 2:39:03 PM

Page 2

Item ID: D3953-19

Accept

Setup Start

Revision ID:

Stop

Item Name: Gas Spring Bracket

Start Date: 2/17/10 Start Qty: 4.00

Cust Item ID:

Required Date: 2/24/10 Req'd Qty: 4.00

Customer:

Reference:

Run Start

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

8/10/23

10

QC

Memo

0.00

Quality Control

130

0.00

Small Fab

Memo

0.00

Small Fab

1- CHAMFER HOLE AS PER DWG

2- DEBURR IF NECESSARY

8/10/23 10

140

QC5- Inspect part completeness to step on W/O

0.00

8/10/23

10

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 56324

February 17, 2010 2:39:03 PM

Page 3

Item ID: D3953-19

Accept

Setup Start

Revision ID:

Stop

Item Name: Gas Spring Bracket

Start Date: 2/17/10 Start Qty: 4.00

Cust Item ID:

Required Date: 2/24/10 Req'd Qty: 4.00

Customer:

Reference:

Run Start

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Identify as per dwg & Stock Location: 119

0.00

-1 'For Basket.



Packaging

Memo

0.00

Packaging

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

P. 10/26 (F)

10/03/03 AJ

mf
10-2-23

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

February 17, 2010 4:08:27 PM

Page 1

Work Order ID: 56324



Parent Item: D3953-19



Parent Item Name: Gas Spring Bracket



Start Date: 2/17/10

Required Date: 2/24/10

Comments: IPP RevA: new issue DD 09.11.30 verified by:EC

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S11GA 		Purchased	No			100	sf	72.2036	0.0758	3		
304/316 0.125 Sheet												

HR 10-2-22

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

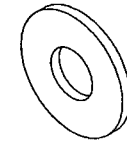
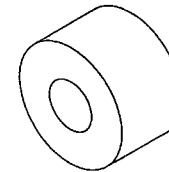
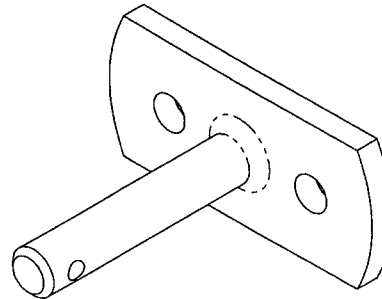
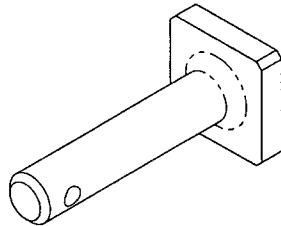
112663

72.2036

72.2036

(16)

112663



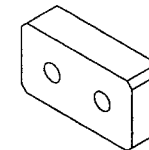
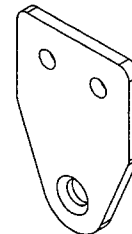
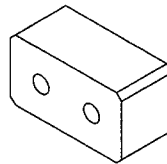
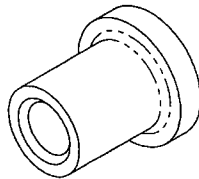
D3953-1 GAS SPRING BRACKET
(FULL LID)

D3953-3 GAS SPRING STUD, LID

D3953-5 GAS SPRING STUD, BASE

D3953-7 GAS SPRING SPACER

D3953-9 GAS SPRING WASHER



D3953-11 GAS SPRING SPACER

D3953-13 GAS SPRING SPACER
(FULL LID)

D3953-15 GAS SPRING BRACKET
(SPLIT LID)

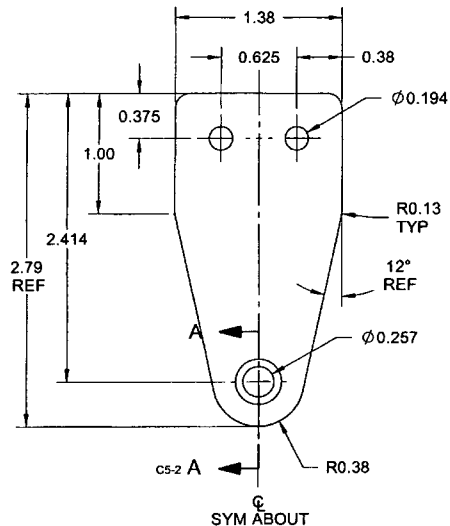
D3953-17 GAS SPRING SPACER
(SPLIT LID)

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2009-11-25
AP

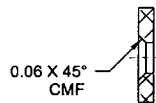
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RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
56324

RY10-2-17

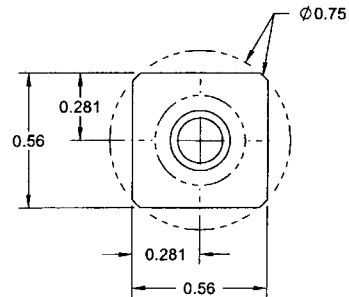
B	SHEET 3 ZONE C1, DIM 0.05 MIN WAS 0.13, MULTIPLE DIMENSIONS MIN/MAX REMOVED TOLERANCE ADDED. REASON: DIFFICULTY INSTALLING COTTER PIN AT NEXT ASSY.	AJS	09.11.11
A	NEW ISSUE	AJS	09.07.27
REV.	DESCRIPTION	BY	DATE
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DRAWN	AJS		
CHECKED	B	DRAWING NO.	REV. B
MFG. APPR.	B	D3953	SHEET 1 OF 4
APPROVED	140	TITLE	SCALE
DE APPR.	#	GAS SPRING LID COMPONENTS	NTS
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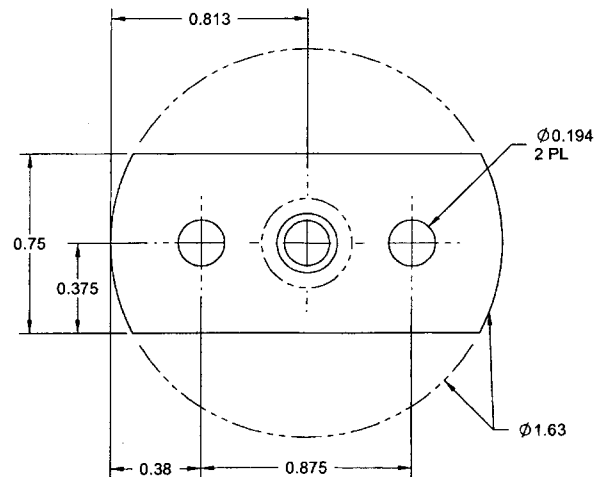
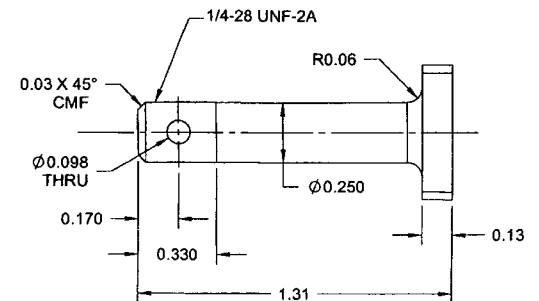
D3953-1 GAS SPRING BRACKET
(FULL LID)



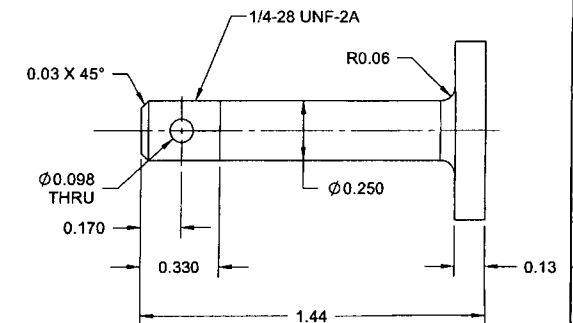
SECTION A-A C7-2



D3953-3 GAS SPRING STUD, LID



D3953-5 GAS SPRING STUD, BASE



NOTES:
1) MATERIAL: AISI 304 STAINLESS STEEL SHEET, 0.125 THICK
REF DART SPEC M304S

-3 & -5: AISI 304 STAINLESS STEEL BAR
REF DART SPEC M304B

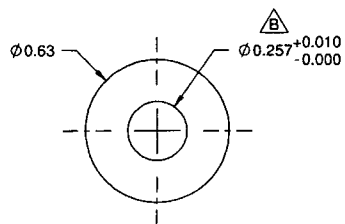
OR: AISI 304/316 STAINLESS STEEL ROD
REF DART SPEC M304R

- 2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3953-X" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: -1: 0.11 lbs
-3: 0.03 lbs
-5: 0.06 lbs

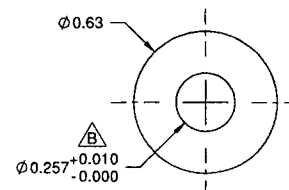
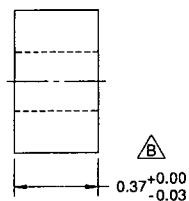
W/O 56324

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2009-11-25

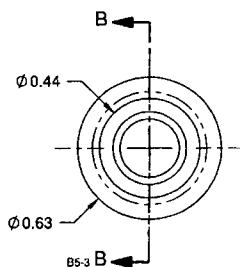
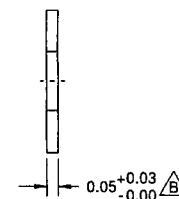
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CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3953	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		GAS SPRING LID COMPONENTS	NTS
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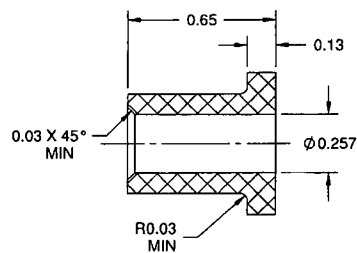
D3953-7 GAS SPRING SPACER



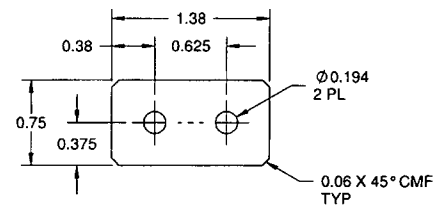
D3953-9 GAS SPRING WASHER



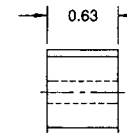
D3953-11 GAS SPRING SPACER



SECTION B-B 87-3



D3953-13 GAS SPRING SPACER



NOTES:

1) MATERIAL -7, -9 & -11: DELRIN II 150E OR ACETRON GP ACETAL, BLACK
REF DART SPEC M-DELRIN-R

-13: AISI 304 STAINLESS STEEL BAR
REF DART SPEC M304B

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION -13 ONLY: IDENTIFY WITH DART P/N "D3953-13" USING FINE POINT PERMANENT INK MARKER

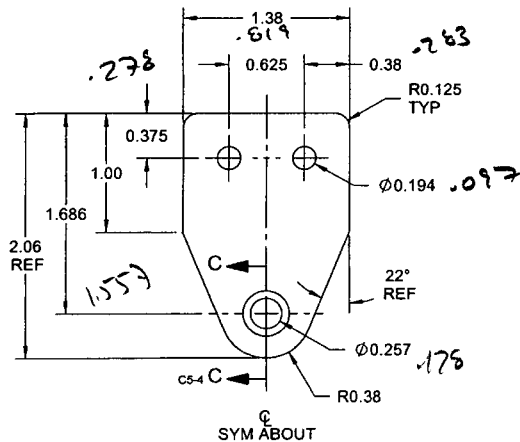
7) WEIGHT -7/-9/-11: < 0.01 lbs EACH

-13: 0.17 lbs

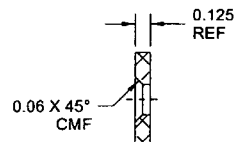
W/0 56324

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2009-11-25
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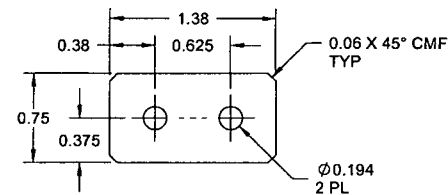
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APPROVED	40	TITLE	SCALE
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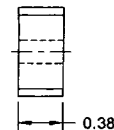
D3953-15 GAS SPRING BRACKET
(SPLIT LID)



SECTION C-C C7-4



D3953-17 GAS SPRING SPACER
(SPLIT LID)



w/o 56324

NOTES:

1) MATERIAL -15: MATERIAL: AISI 304 STAINLESS STEEL SHEET, 0.125 THICK
REF DART SPEC M304S

-17: AISI 304 STAINLESS STEEL BAR
REF DART SPEC M304B

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3953-X" USING FINE POINT PERMANENT INK MARKER

7) WEIGHT -15: 0.08 lbs

-17: 0.10 lbs

RELEASED
2009-11-25
JMP

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DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3953	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		GAS SPRING LID COMPONENTS	NTS
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